

Ship today

Work Order ID 144086

144086

Page 1

Friday, April 01, 2016 12:57:24 PM

Item ID: D350-578-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: AS350/AS355 Bearpaws
 Start Date: 4/1/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/1/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MUF Date: 16-3-1 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-578	H								MLJ 16-04-01

100 Document Control 0.00
100
 DC DOCUMENT CONTROL
 Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D350-578-011 CHG006

DAS
27
9-89

APR 01 2016

160 Pick Kit 0.00
160
 Packaging Memo 0.00
 Packaging

DAS DAS
6 28
9-89 9-89

APR 01 2016

170 QC4- 100% Inspect kits for completeness 0.00
170
 QC Memo 0.00
 Quality Control

DAS
27
9-89

APR 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144086

Friday, April 01, 2016 12:57:24 PM

144086

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Item ID: D350-578-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Bearpaws

Start Date: 4/1/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: _____								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
APR 01 2016

MCS APR 01 2016

MCS APR 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval:		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 144086

144086

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 4/1/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2432 *D2432* Bearpaw 19" X 24"		Manufactured	No			160	Each	2.0000	2	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					DAS 28 9-89
				ST				2					
					140477			2					
D2529 *D2529* Washer		Manufactured	No			160	Each	368.0000	12	12			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					DAS 28 9-89
				ST009				368					
					141458			368					
D3601-1 *D3601-1* Radius Block		Manufactured	No				Each	176.0000	12	12			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					DAS 28 9-89
				ST046				176					
					141269			176					

APR 01 2016

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Work Order ID: 144086

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Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 4/1/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

D4011-1
D4011-1
Clamp, Short

Manufactured No

Each 138.0000

**

DAS
27
9-89

DAS
28
9-89

Location Loc Qty Loc Code

ST544 38

141268 38

ST546A 100

141469 100

Manufactured No

Each 49.0000

**

DAS
27
9-89

DAS
28
9-89

Location Loc Qty Loc Code

FG 5

133458 5

ST545 44

140474 44

Purchased No

Each 327.0000

**

DAS
27
9-89

DAS
28
9-89

Location Loc Qty Loc Code

FG 5

121541 5

over003 100

M134502 100

ST343 222

M128813 12

M134055 10

M134134 200

AN4-16A
AN4-16A
Bolt

Purchased No

Each 327.0000

**

DAS
27
9-89

DAS
28
9-89

Location Loc Qty Loc Code

FG 5

121541 5

over003 100

M134502 100

ST343 222

M128813 12

M134055 10

M134134 200

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Friday, April 01, 2016 12:57:23 PM

Work Order ID: 144086

144086

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 4/1/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

160

Each

4,057.000

24

24

NAS1149D0463.J

WASHER

Location

Loc Qty

Loc Code

GA

136

M129390

41

M132035

95

ST260a

2000

M134573

2000

ST263

933

M134039

933

ST269

988

M132317

100

M132677

888

MS21042L4

Purchased

No

160

Each

2,049.000

12

12

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

381

m133769

381

OVER007

1500

m134502

1500

ST303

34

m134055

34

ST305

97

m130922

97

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

REFERENCE ONLY

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
(2)						D2432F	Bearpaw)
		2				D2432-3	Bearpaw
(12)	12	12	12	12		D2529	(Washer)
				2		D2672F	Bearpaw
(12)	12	12	12	12		D3601-1	Radius Block (Replaces D2274)
					2	D3859-041	Wearplate
(6)	6	6	6	6		D4011-1	(Clamp (Replaces D2438)
(6)	6	6	6	6		D4012-1)	Cushion (Replaces D2182B050)
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
(12)	12			12	12	AN4-16A-	(Bolt)
		12	12		12	AN4-17A	Bolt
(24)	24	24	24	24	24	NAS1149D0463J	Washer)
(12)	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

Qty -111	Qty -113	Qty -115	Qty -117	Qty -121	Part Number	Description
X					D350-578-111	BEARPAW INSTALLATION
	X				D350-578-113	BEARPAW INSTALLATION
		X			D350-578-115	BEARPAW INSTALLATION
			X		D350-578-117	BEARPAW INSTALLATION
				X	D350-578-121	BEARPAW INSTALLATION
1					D350-578-011	Bearpaw Installation
	1				D350-578-013	Bearpaw Installation
		1			D350-578-015	Bearpaw Installation
			1		D350-578-017	Bearpaw Installation
				1	D350-578-021	Bearpaw Installation
1	1	1	1	1	D350-578-031	Wearplate Kit